

Del 1.25 Work Order ID 83318

Tuesday, April 17, 2012 1:15:07 PM

83318

Page 1

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Washer

Start Date: 4/17/2012 Start Qty: 50.00 *50* Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 50.00 *50* Customer:

Reference:

Approvals: Process Plan: R Date: 12-04-17 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev F								

<p>100</p> <p>*100*</p> <p>Doosan</p> <p>Doosan Lathe</p>	<p>Hardinge CNC LATHE SMALL</p> <p>Memo</p> <p>1-Turn as per Folio FA761</p> <p>Rev: <u>AA</u> &</p> <p>Dwg D3417 Rev: <u>F</u></p> <p>2-Deburr</p>	<p>0.00</p> <p>0.00</p>	<p><u>SL</u> <u>12/5/12</u></p>	<p><u>50</u> <u>φ</u></p>
<p>110</p> <p>*110*</p> <p>QC</p> <p>Quality Control</p>	<p>QC2- Inspect parts off machine FAI/FAIB</p> <p>Memo</p>	<p>0.00</p> <p>0.00</p>	<p><u>SL</u> <u>12/5/12</u></p>	<p><u>50</u> <u>φ</u></p>
<p>120</p> <p>*120*</p> <p>QC</p> <p>Quality Control</p>	<p>QC8- Inspect parts - second check</p> <p>Memo</p>	<p>0.00</p> <p>0.00</p>	<p><u>ork</u> <u>12/05/14</u></p>	<p><u>50</u> <u>φ</u></p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83318

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Page 2

Item ID: D3417-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 4/17/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: 8742

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

50x62-5-1412/5/15mf
12-05-14

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Picklist Print

Page 1

Tuesday, April 17, 2012 1:15:10 PM

Work Order ID: 83318

83318

Parent Item: D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New issue 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased	No			110	f	12.5320	0.0296	1.557895			
									**			12/15/12	
MDFI RINR1 2500													
DELRIN ROUND BAR 1.25"													

Location

Loc Qty

Loc Code

MAT055

12.532

114586

1.449

119133

11.083

1.6

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	10.11.12	Dwg Rev updated	KJ	

Dart Aerospace Ltd

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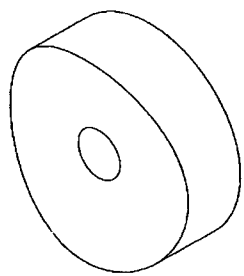
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

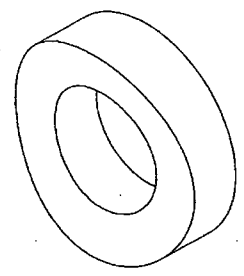
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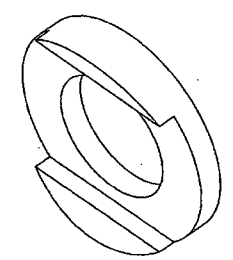
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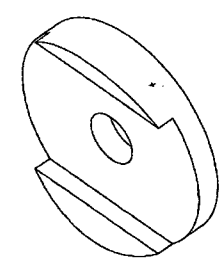
D3417-1 WASHER



D3417-3 WASHER

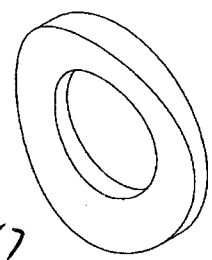


D3417-5 WASHER



D3417-7 WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83315



D3417-9 WASHER

RELEASED
2010-09-15

- NOTES:
1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

pl (12-07-17)

REV.	DESCRIPTION	BY	DATE
F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
DESIGN		SC	
DRAWN		SC	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE		10.07.26	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. F	
D3417		SHEET 1 OF 3	
TITLE		SCALE	
WASHER		NTS	
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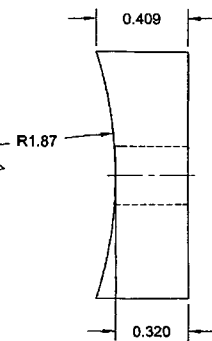
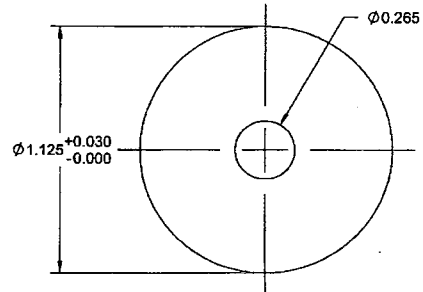
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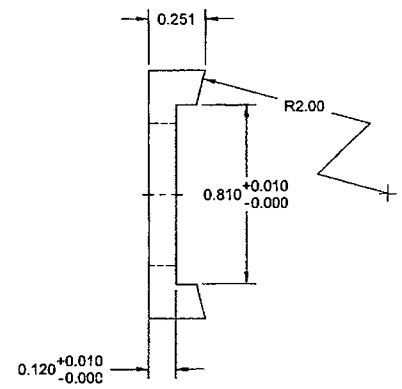
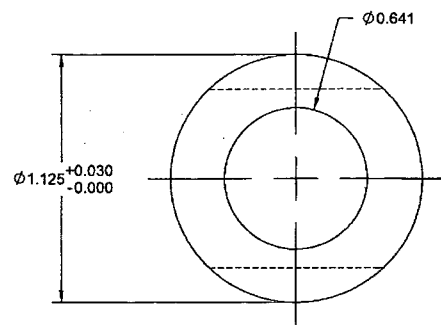
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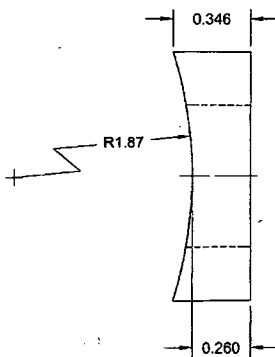
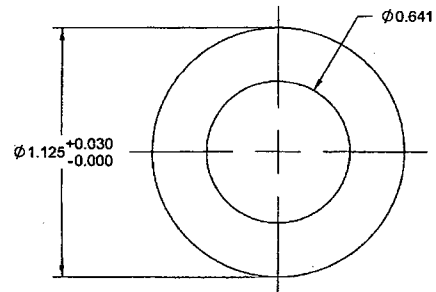
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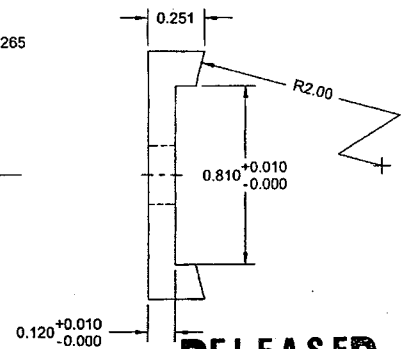
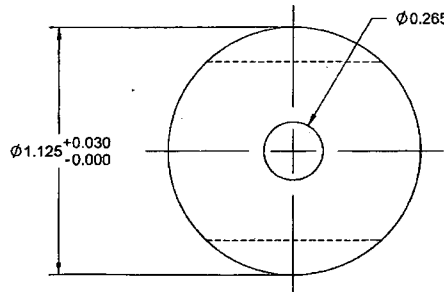
D3417-1 WASHER



D3417-5 WASHER



D3417-3 WASHER



D3417-7 WASHER

8 3318

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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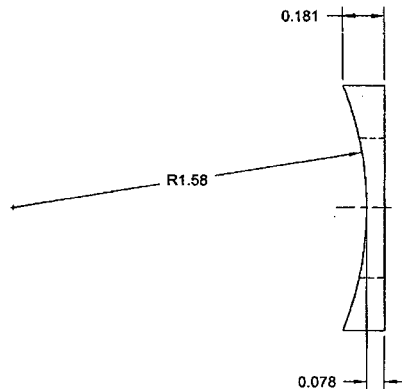
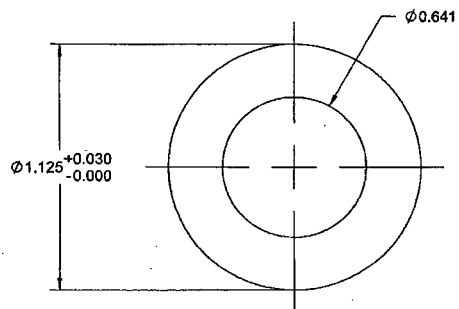
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D3417-9 WASHER



83318

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MS

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